

Work Order ID 78033

December-28-11 8:09:07 AM

78033

Page 1

Item ID: D3913-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long Basket Base Assembly, 350

Start Date: 28/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/28

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3913

A

D4020

A

100

Weld per dwg A/R S.S. rod Batch: 117884 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3913 using DT9610A

inspect before welding mesh

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D3913

take lid to locate hinge and bracket

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

PL 12.01.05 1x

12.01.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Start Date: 28/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/01/2012 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Memo

0.00

Quality Control

m 12 01 06 (1)

125 Pressure Wash per QSI005 4.3 0.00

125

HandFinish

Memo

0.00

Hand Finishing

IXP m-12/01/09

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 11:40OVEN TEMPERATURE: 400°FFINISH TIME: 12:12

*****2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1X M/L 12/01/09

140	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

140

QC

Quality Control

Memo

0.00

1 BR 12-1-9

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Assemble as per dwg	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing	Pick Kit								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: D4030-041	0.00							
170									
Packaging	Memo	0.00							
Packaging									

78028.

1 BR 12-1-9.

W/O:		WORK ORDER CHANGES					
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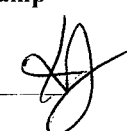
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/11 
ME
12-01-10

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581

Manufactured

No

100

Each

89.0000

2

2

D2581

Mounting Bracket

**

Location

Loc Qty

Loc Code

WA005

89

69739

1

70766

2

75280

9

77045

48

77523

29

D3913-1

Manufactured

No

100

Each

0.0000

1

1

D3913-1

Rib

D3913-15

Manufactured

No

100

Each

5.0000

1

1

D3913-15

Wide Handle Plate

**

Location

Loc Qty

Loc Code

WA005

5

74640

5

D3913-3

Manufactured

No

100

Each

6.0000

1

1

D3913-3

Rib

**

Location

Loc Qty

Loc Code

WA006

6

69160

1

74144

1

74904

4

W/O:		WORK ORDER CHANGES					
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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-7

Manufactured No

100

Each

4.0000

2

2

D3913-7

Rib

**

Pl 12.01.03

Location

Loc Qty

Loc Code

WA006

4

74683

4

100

Each

6.0000

1

1

**

Pl 12.01.03

D3913-9

Manufactured No

D3913-9

Hinge Rib

Location

Loc Qty

Loc Code

WA006

6

70138

1

74143

1

74902

4

100

Each

4.0000

2

2

**

Pl 12.01.03

D3916-041

Manufactured No

D3916-041

Rib Assembly

Location

Loc Qty

Loc Code

WA006

4

69161

2

74773

2

100

Each

2.0000

3

3

**

Pl 12.01.03

D3916-5

Manufactured No

D3916-5

Light Rib

Location

Loc Qty

Loc Code

WA006

2

74920

2

375300

2

1

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Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4016-1

Manufactured No

100

Each

28.0000

3

3

D4016-1

Hinge Half, Base

**

Pl 12.01.03

Location

Loc Qty

Loc Code

WA005

28

74140

10

75281

18

3

D4017-7

Manufactured No

100

Each

4.0000

1

1

D4017-7

Rib

**

Pl 12.01.03

Location

Loc Qty

Loc Code

WA005

4

69730

1

74638

3

1

D4017-9

Manufactured No

100

Each

8.0000

2

2

D4017-9

Rib

**

Pl 12.01.03

Location

Loc Qty

Loc Code

WA006

8

70341

2

73531

4

74684

2

2

D4020-11

Manufactured No

100

Each

7.0000

2

2

D4020-11

End Mesh, Basket

**

Pl 12.01.05

Location

Loc Qty

Loc Code

WA035

7

69648

2

74386

1

75621

4

2

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Shop Packet Print

Page 3

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Work Order ID: 78033

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-1 Manufactured No

100

Each

18.0000

3

3

D4021-1

Handle Plate

**

PL12.01.03

Location

Loc Qty

Loc Code

WA005

18

74946

9

3

9

100

Each

1.0000

1

1

D4034-041

Manufactured No

D4034-041

Aft Upper Rib Assembly

**

PL12.01.03

Location

Loc Qty

Loc Code

WA006

1

74139

100

Each

1.0000

1

1

D4034-043

Manufactured No

D4034-043

Fwd Upper Rib Assembly

**

PL12.01.03

Location

Loc Qty

Loc Code

WA006

1

74146

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

595.5774

33

33

M304EX0 75-16F

Expanded Metal Flat SS

**

Pl 12-01-05

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

595.577296

117197

102.9036

117896

38.3264

118153

76.8473

118248

3.0983

118597

21.06788

118955

82.17

119180

64.537916

119729

206.6259

AN3-10A

Purchased

No

150

Each

137.0000

6

6

AN3-10A

Bolt

**

Q

Location

Loc Qty

Loc Code

GA

95

119084

95

ST351

42

117795

26

119128

16

AN960JD8

NAS1149DN832

Purchased

No

150

Each

0.0000

2

2

AN960JD8

Washer

**

117795

119717

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No 150 Each 538.0000 2 2

D2931

Bumper

**

46064

[Signature]

Location

Loc Qty

Loc Code

ST504

538

46064

538

D4021-5 Manufactured No 150 Each 22.0000 2 2

D4021-5

Blanking Plate

**

[Signature]

Location

Loc Qty

Loc Code

GA

22

73478

22

MS20600-AD4W3 Purchased No 150 Each 1,029.000 2 2

MS20600-AD4W3

Cherry Rivets

**

73478

[Signature] 12/1/12

Location

Loc Qty

Loc Code

ST321

896

111636

36

117505

115

117601

35

118626

710

118626

WA018

133

107939

133

W/O:		WORK ORDER CHANGES					
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Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

6,837.000

6

6

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

ST300

6837

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

793

119017

NAS1149F0332P

Purchased

No

150

Each

348.0000

12

12

NAS1149F0332P

**

WASHER

Location

Loc Qty

Loc Code

ST275

348

117735

45

119225

300

17317

3

119225

Dart Aerospace Ltd

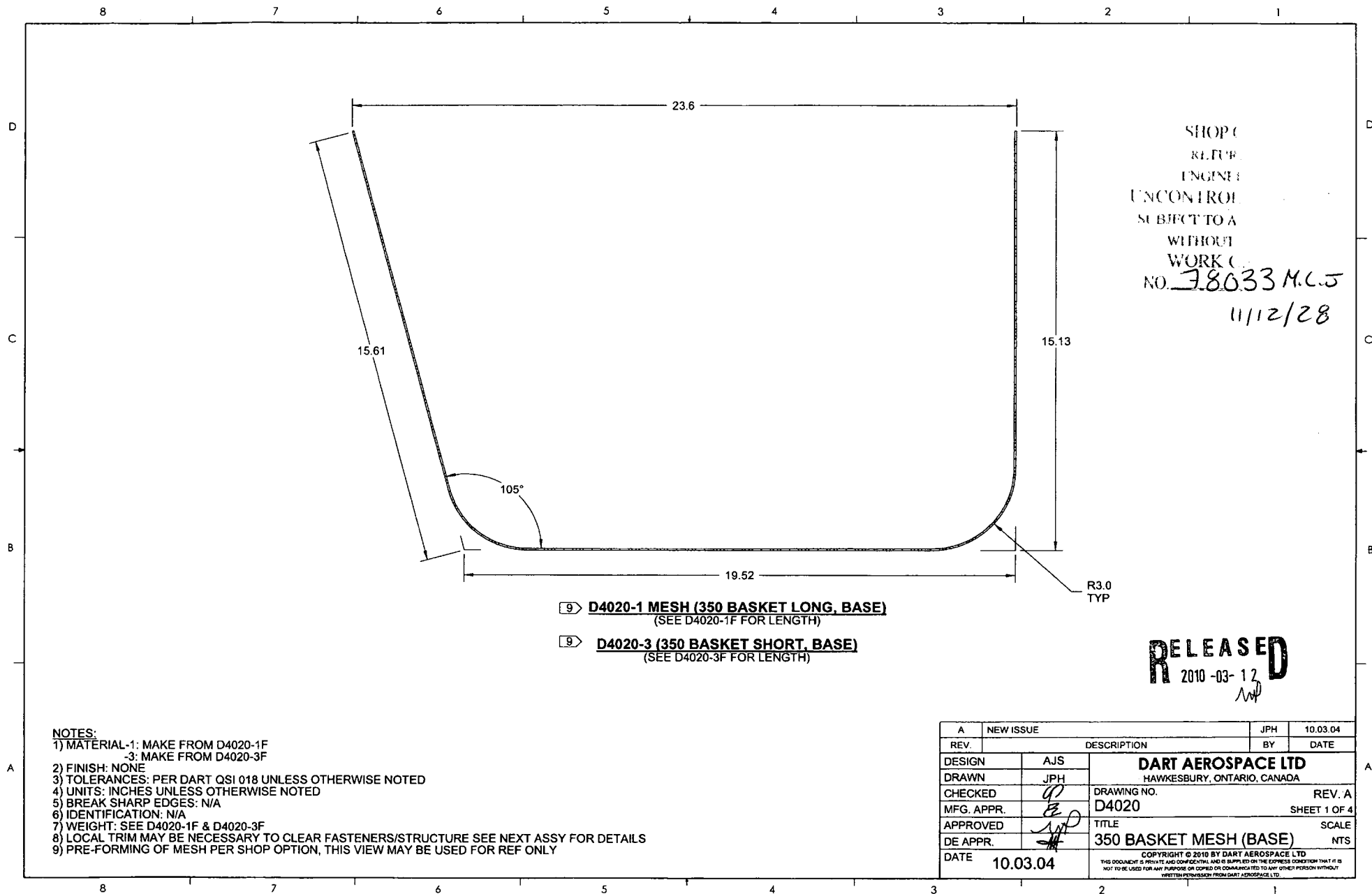
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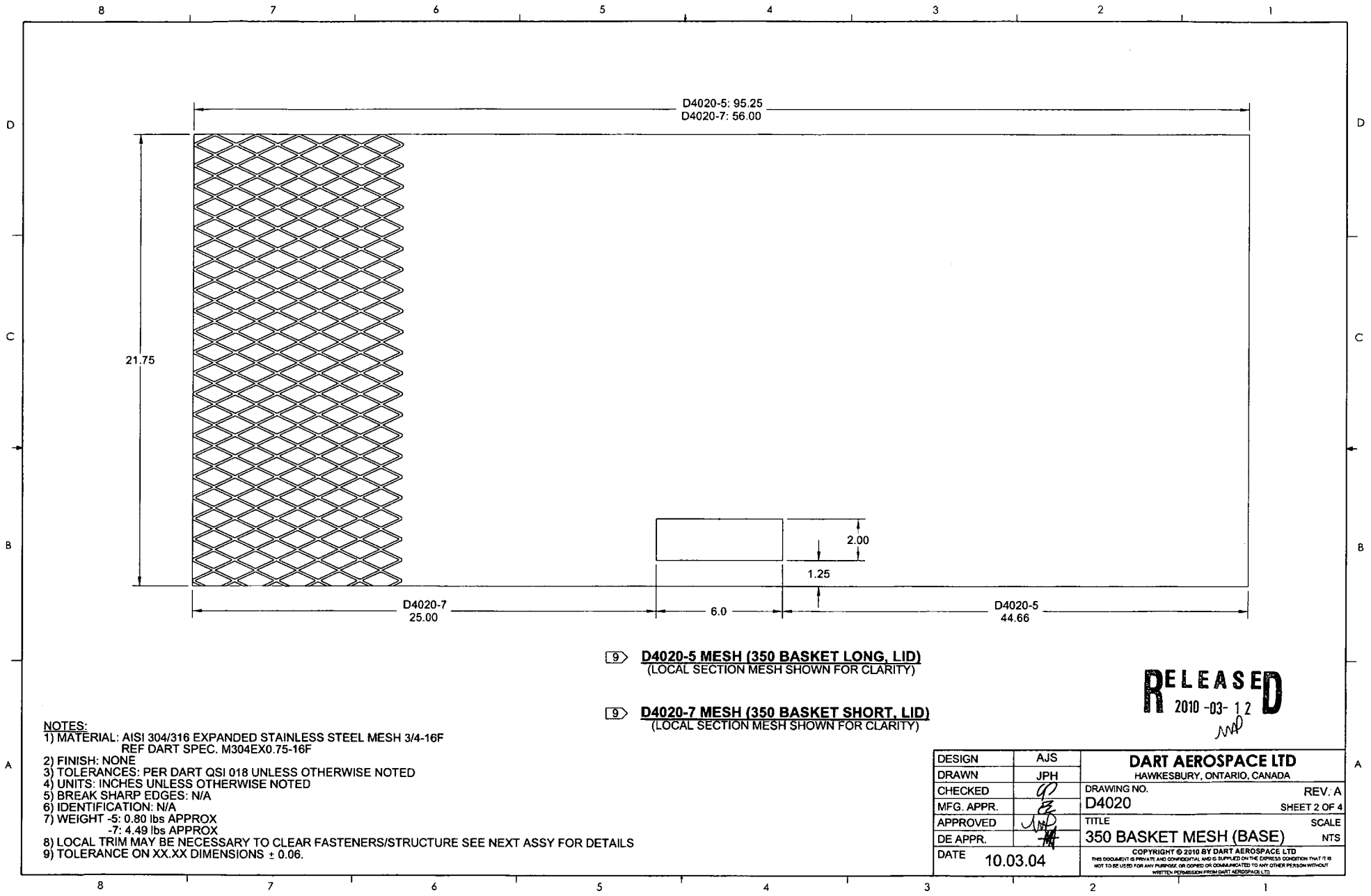
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- 9) **D4020-5 MESH (350 BASKET LONG, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)
- 9) **D4020-7 MESH (350 BASKET SHORT, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:
 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
 REF DART SPEC. M304EX0.75-16F
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT -5: 0.80 lbs APPROX
 -7: 4.49 lbs APPROX
 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
 2010-03-12
MD

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JP</i>	D4020	SHEET 2 OF 4
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

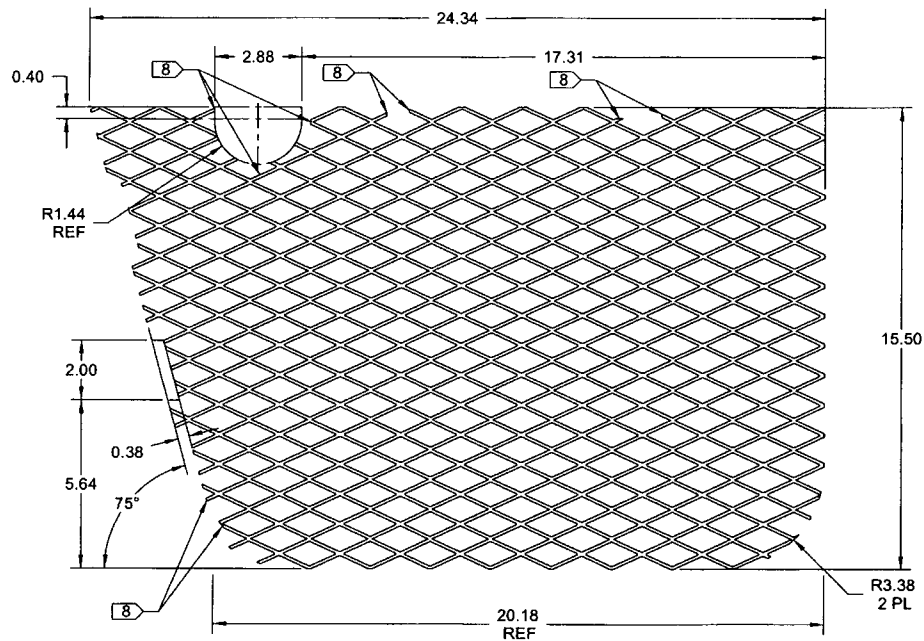
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78033



9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
JMP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

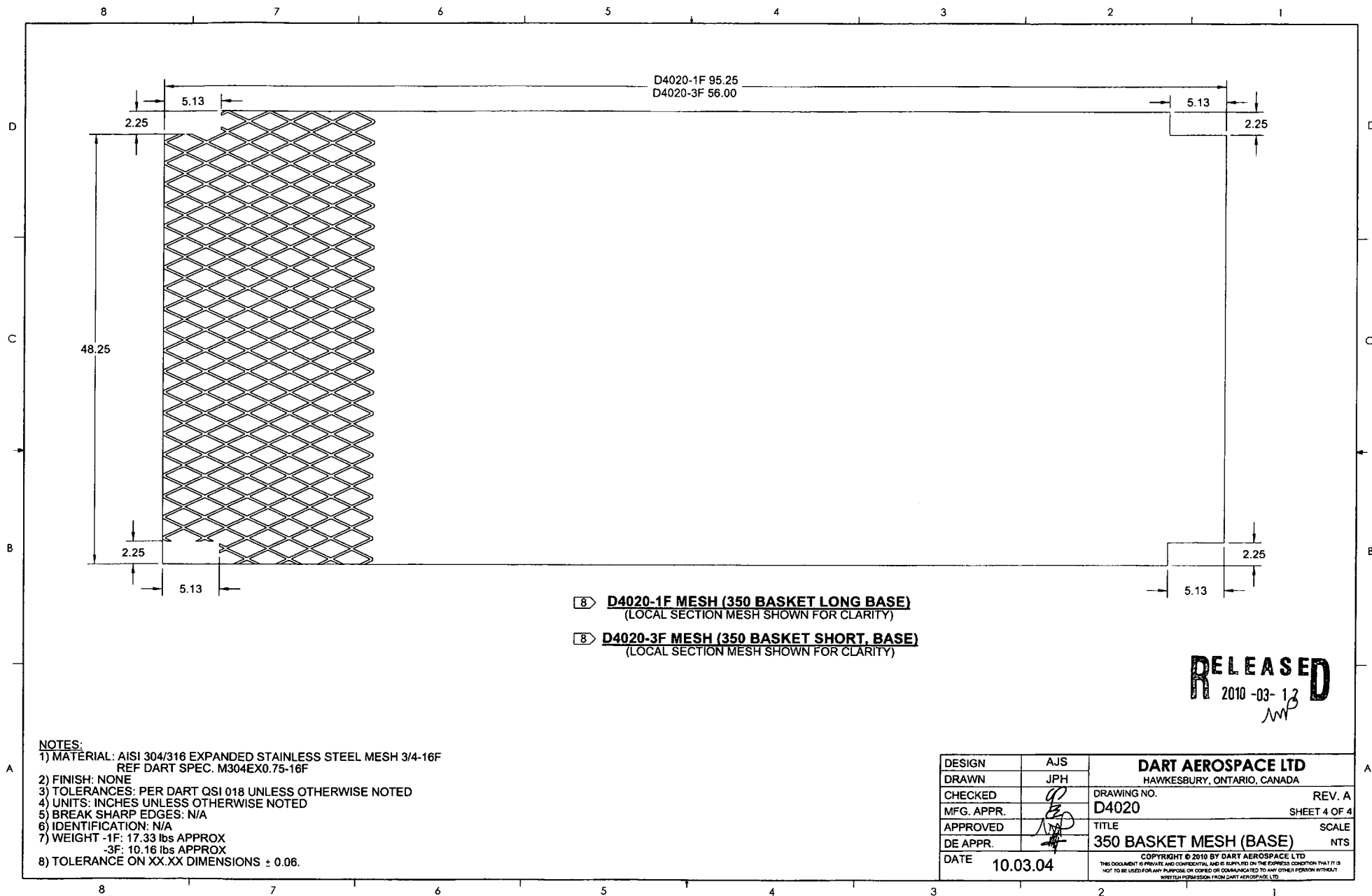
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78033



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

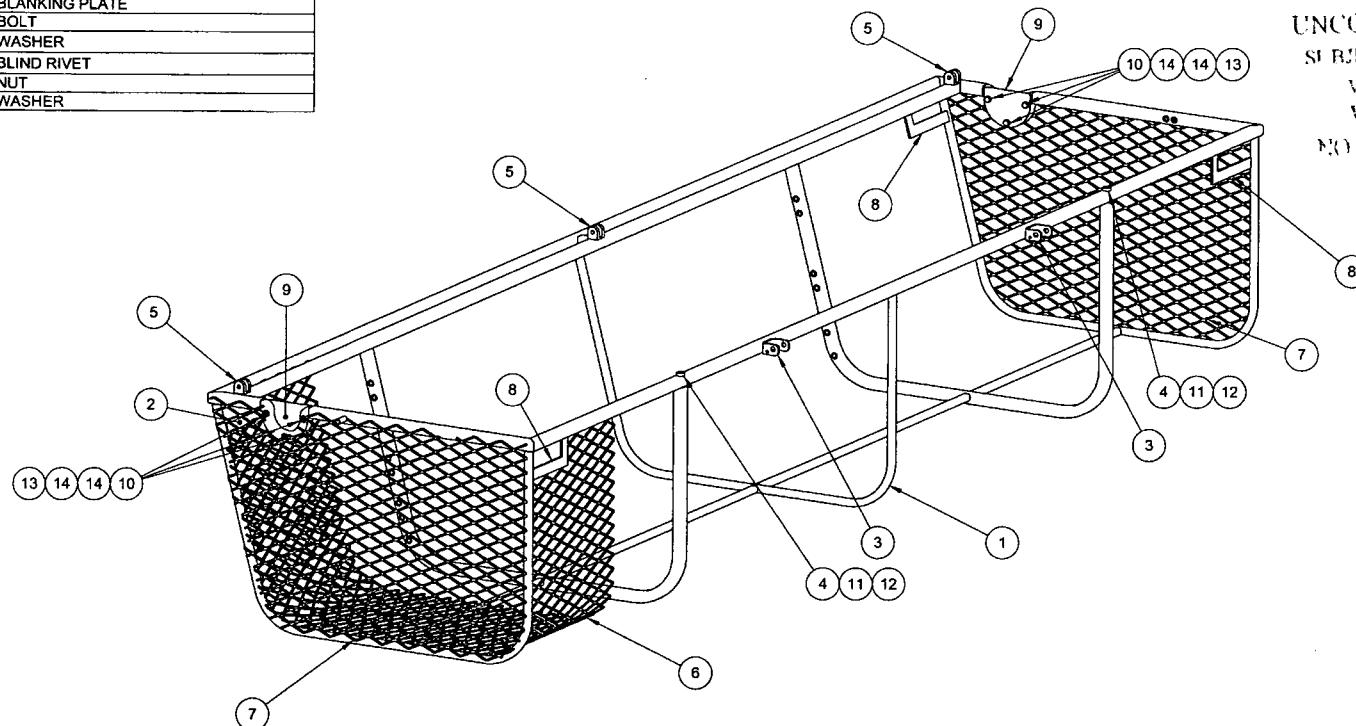
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7803B

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JDB	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY
UNCONTROLLED COPY
SUBJECT TO VERIFICATION
WITHIN 30 DAYS
WORK ORDER
NO. 7803346J
11/12/28

RELEASED
2010-03-22

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3913
REV. A
SHEET 1 OF 6
TITLE
LONG BASKET BASE ASSY (350) NTS
SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

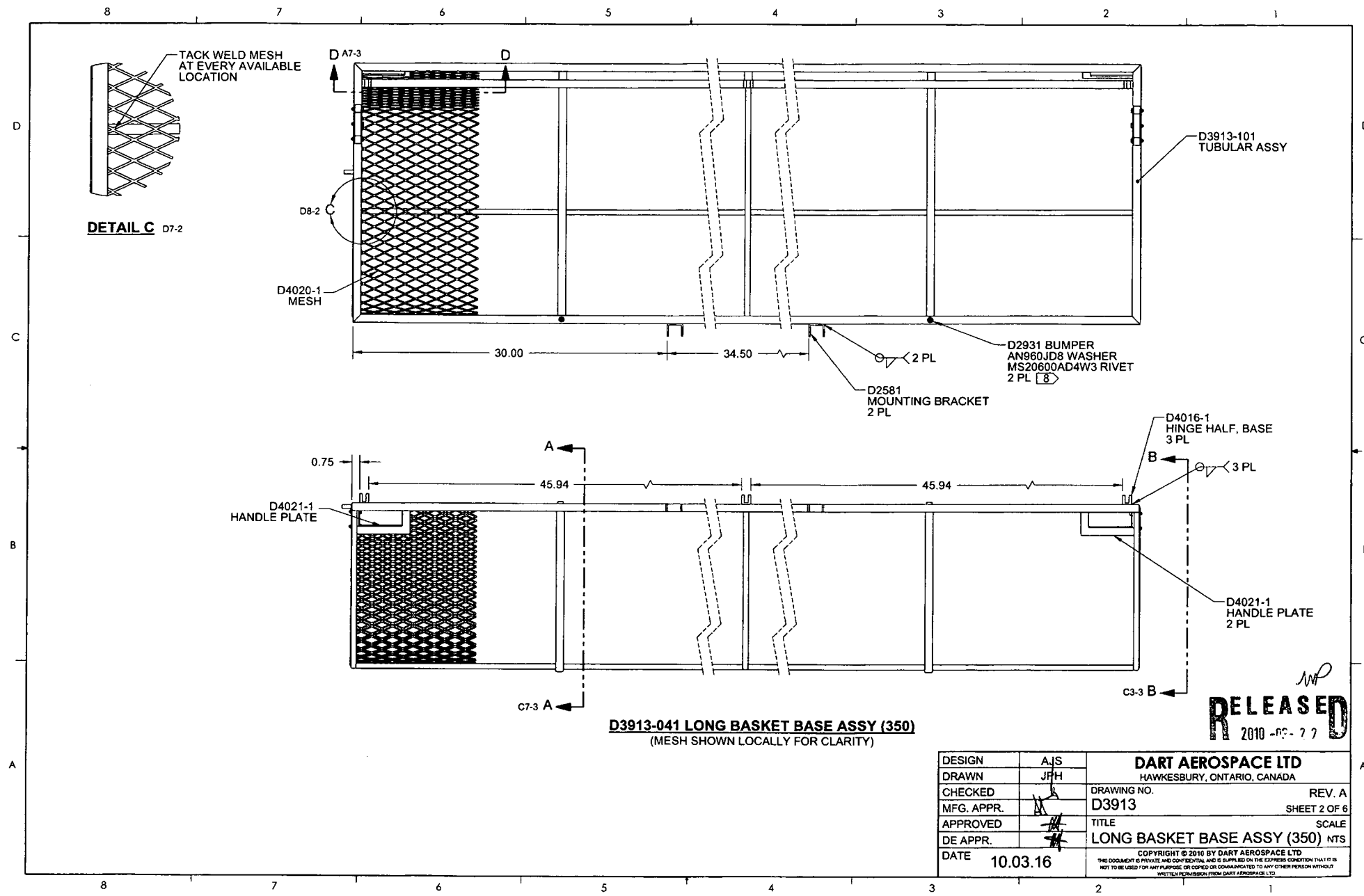
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7803B



RELEASED
2010-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

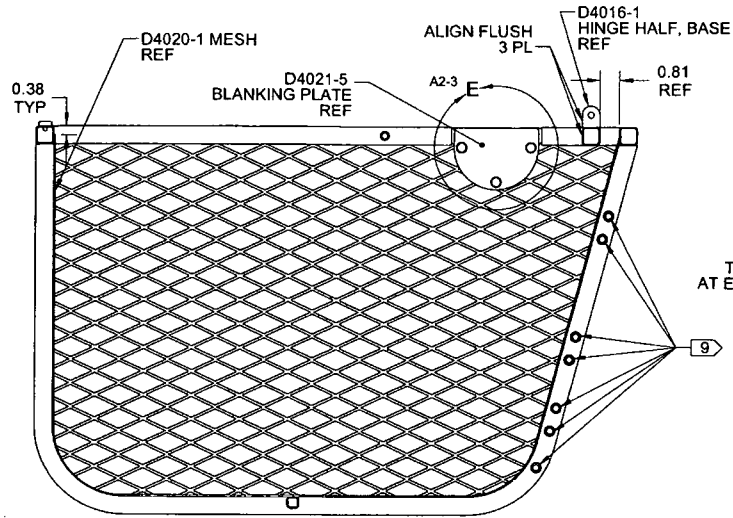
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

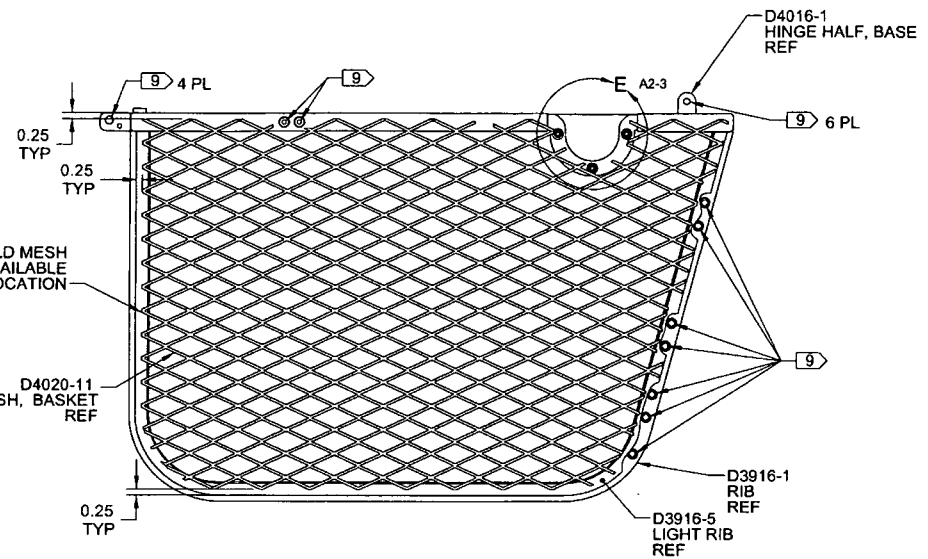
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

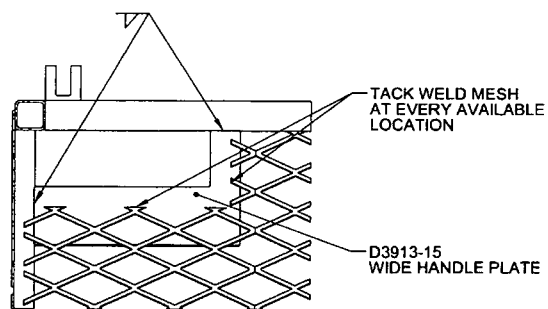
7803B



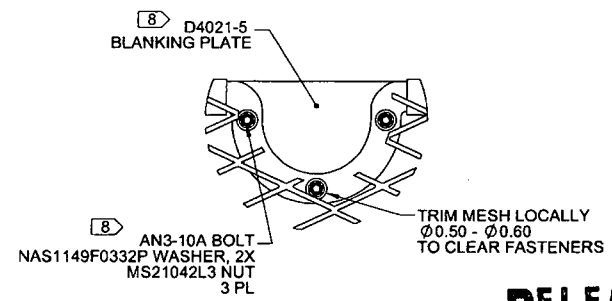
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

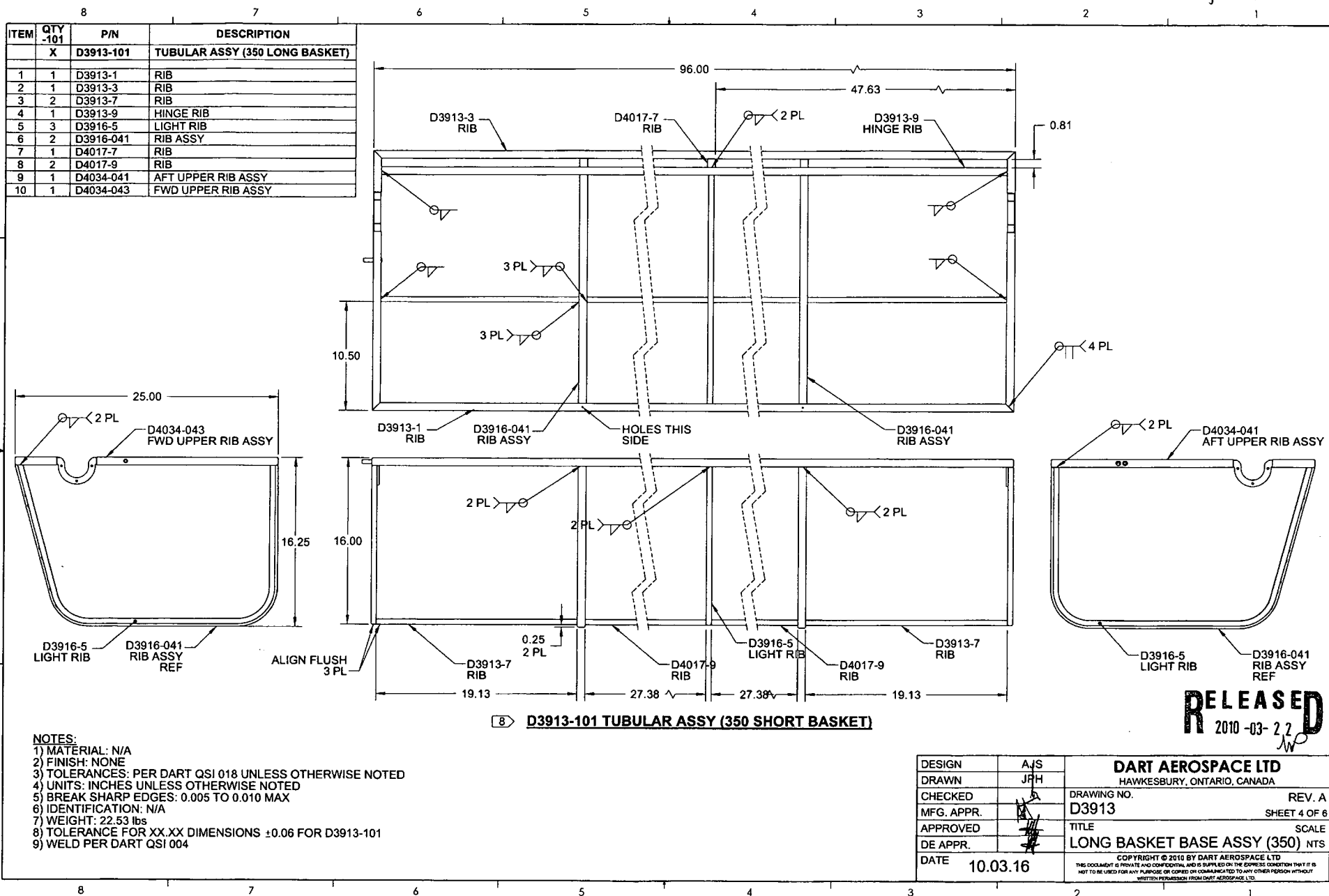
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78033



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

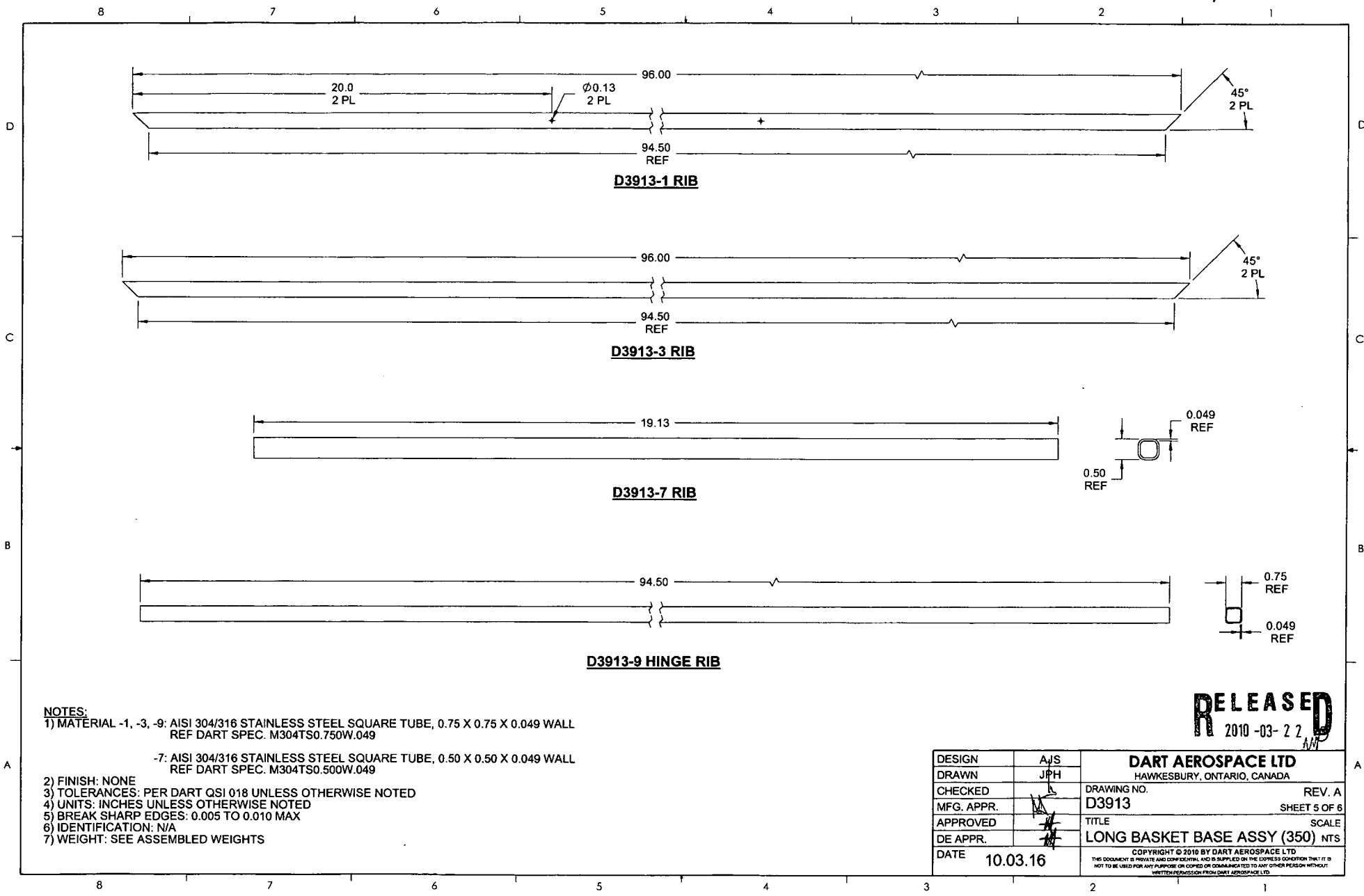
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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78033



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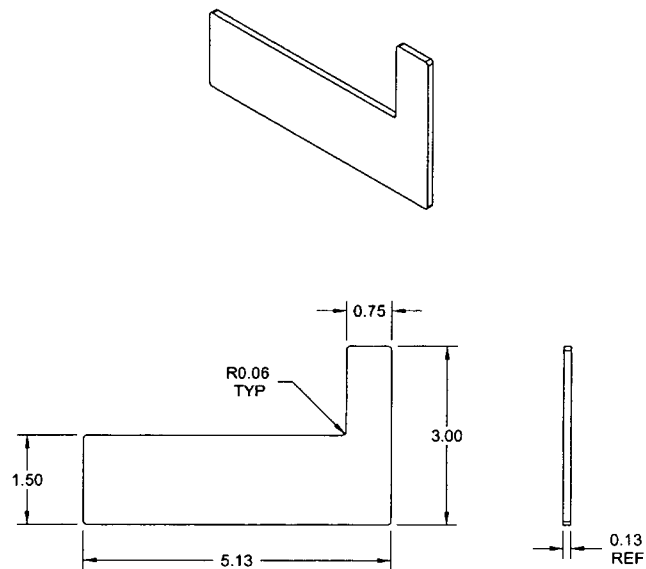
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78033

**D3913-15 WIDE HANDLE PLATE****NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
 2010-03-22
WJP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3913	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 6	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350) NTS	
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NOTE: Date & initial all entries